

Work Order ID 74040

Tuesday, September 20, 2011 4:07:00 PM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Item Name: Rear Locker Extender

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: P Date: 11-09-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

W 11-11-02 (1)
for MS 11-11-01

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14968
Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 118800

11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74040

Page 2

Tuesday, September 20, 2011 4:07:00 PM

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Accept



Setup Start



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Stop



Start Date: 9/20/2011 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00							
	Memo	0.00							
	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Check hole locations to template. DT 8824 Check process sheet and audit.								
140 Packaging	Pick Kit	0.00							
	Memo	0.00							

Pa 11/11/01

11 - 11 - 01 (1)

11/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 74040



Page 3

Tuesday, September 20, 2011 4:07:00 PM

Item ID:	D350-604-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rear Locker Extender					
Start Date:	9/20/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/10/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00				<i>W</i>	<i>11-</i>	<i>11-02</i>	<i>①</i>
160 	Packaging	0.00							
Packaging Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D350-604-041								
	Location: _____								
	PPP Rev: _____								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Supp 3

11/11/3

MF
11-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 4:13:12 PM

Page 1

Work Order ID: 74040

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender







Start Date: 9/20/2011

Required Date: 10/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: Q ☐ 03.12.01 ☐ Reformat ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
2600-6  Camlock Stud		Purchased	No			110	Each	303.0000	4	4																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST380</td><td>303</td><td></td></tr><tr><td>118611</td><td>1</td><td></td></tr><tr><td>118752</td><td>16</td><td></td></tr><tr><td>118800</td><td>196</td><td></td></tr><tr><td>118852</td><td>90</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST380	303		118611	1		118752	16		118800	196		118852	90	
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																													
ST380	303																														
118611	1																														
118752	16																														
118800	196																														
118852	90																														
D350-604-041P  Rear Locker Extender		Purchased	No			120	Each	0.0000	1	1																					
D2268  Decal		Manufactured	No			140	Each	15.0000	1	1																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST010</td><td>15</td><td></td></tr><tr><td>69592</td><td>5</td><td></td></tr><tr><td>72054</td><td>10</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST010	15		69592	5		72054	10							
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ST010	15																														
69592	5																														
72054	10																														
D2269  Decal		Manufactured	No			140	Each	12.0000	1	1																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST010</td><td>12</td><td></td></tr><tr><td>67421</td><td>2</td><td></td></tr><tr><td>72055</td><td>10</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST010	12		67421	2		72055	10							
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																													
ST010	12																														
67421	2																														
72055	10																														

Rec 11/11/2011 74040

11/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

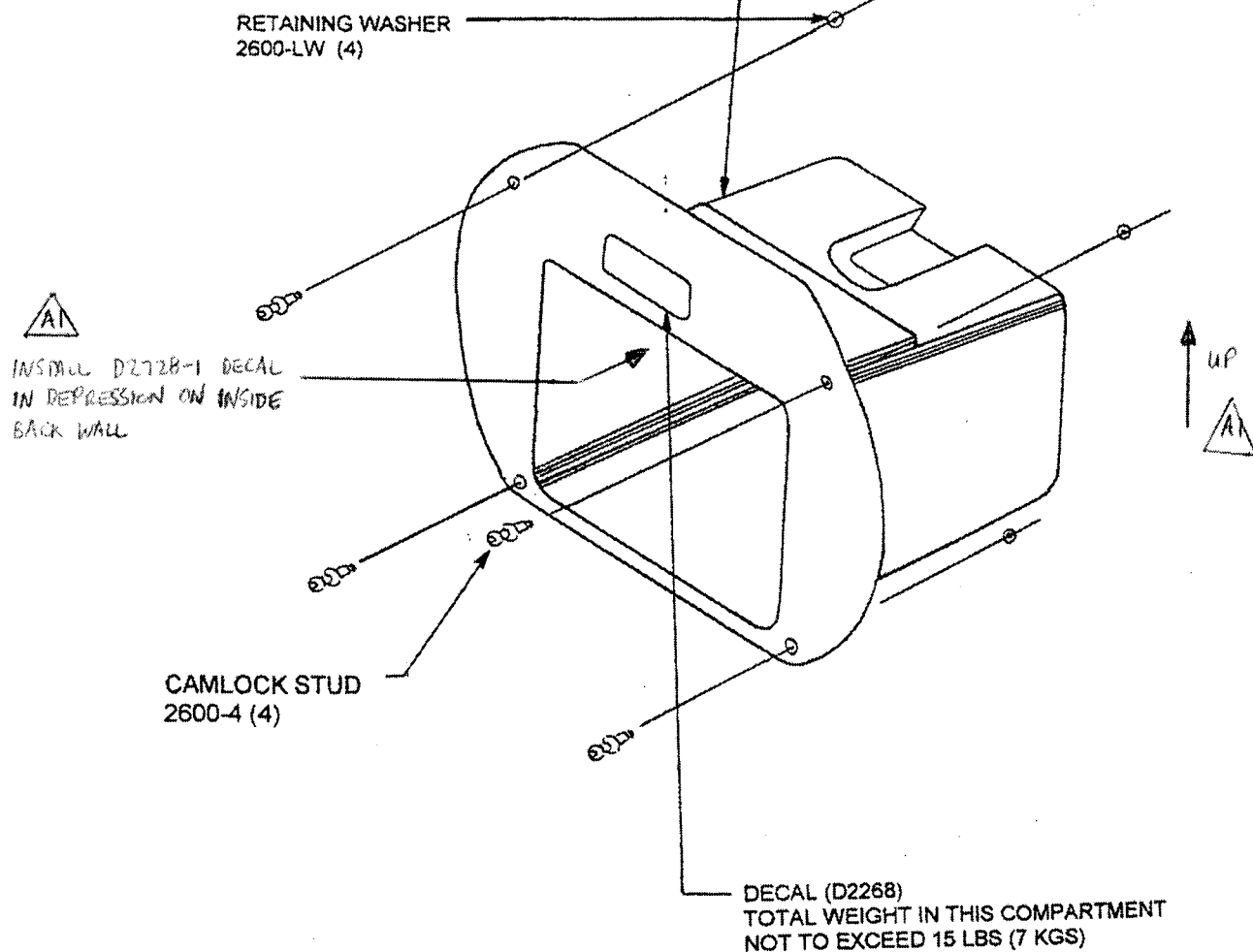
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A.	02.04.01	NEW ISSUE	
A1	02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE	

RELEASED
02.04.03



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	40911
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/10/2011	21/09/2011	18754	Brigitte Golden		PO14968		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B74040 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div><u>No. série</u></div><div><u>No. lot</u></div><div>B74040</div><div>36517</div></div>			
1	0	1	DKC134-0003	Line #4 Rear Locker Extender D350-604-041P B74039 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div><u>No. série</u></div><div><u>No. lot</u></div><div>B74039</div><div>36518</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Vendredi, 2011-10-14 15:59:36
Utilisateur: Pascal Carignan

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 36517	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	: Kit 860	Projet Numéro	: DK-362
Cette fois	: 2011-10-14	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: - -	Date Due	: 2011-10-21
Job précédente	: 36516	Qté:	1 Udm: UNITE

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

B 74040

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: _____ Sceau: _____

2.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-32675-1

3.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0	AC0747	Acetone
-----	--------	---------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 20 oct 11 Sceau: _____



Date: Vendredi, 2011-10-14 15:59:36
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36517

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description:

6.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003.

Date: 21-10-11 Sceau:



7.0 GEL COAT Application du Gel Coat



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1

Date: 21-10-11 Sceau:



8.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 1.680 LITRE(s)/Unit Total: 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-32599-2

9.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-29820-1

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentaire Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentaire Qty.: 1.140 KILOGRAMME(s)/Unit Total: 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50" N° de Lot: 1-28778-1

12.0 LAMINAGE Faire le laminage



Commentaire Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 31 Température: 72F Heure: 2h10

Quantité: 1 Date: 21-10-11 Sceau:



Date: Vendredi, 2011-10-14 15:59:36

Utilisateur: Pascal Carignan

Feuille de ProcédéClient: DART US DART AEROSPACE LTD
Numéro Job: 36517Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-325772

14.0 AMB0286

Catalyst N° DDM-9

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

15.0

FINITION

Finition Générale



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: _____ Date: _____ Sceau: _____

16.0

DÉMOULAGE

Démoulage de la pièce



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: _____ Date: 24-10-11 Sceau: _____



17.0

TRIMAGE

Trimage



Commentaire Setup: 0.00Hrs/ Run: 40.0000Min Total Run: 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1 Date: 24-10-11 Sceau: _____



18.0

AAC1021

Dupont Primer N° 7704S

Commentaire Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30870-1

19.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentaire Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

Date: Vendredi, 2011-10-14 15:59:36
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36517

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:




# Séq.:	Machine ou Opération:	Description :
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20.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 24 oct 11 Sceau:  N° fiche de Mélange: N/A

21.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
------	---------	--

Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)
Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-32365-1

22.0	AAC0682	Washer 2600-LW (1127700)
------	---------	--------------------------

Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)
Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

23.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasquer la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 25-10-11 Sceau: 

24.0	IDENTIFICATION	Identification à encre indélébile
------	----------------	-----------------------------------




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 36517

N° de Fabrication: 25/10/11

Quantité: 1 Date: 25/10/11 Sceau: 

25.0	INSPEC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Vendredi, 2011-10-14 15:59:36
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36517

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date:

25-10-11

Sceau:



26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min . Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date:

25oct 11

Sceau:



fab: 25oct 11

Job: 36517